

Date: Wednesday, 3/26/2008 9:53:42 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 38170	
Estimate Number : 12048	
P.O. Number :	Part Number : D20654711
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D206-547 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 36077	Material :
Written By :	Due Date : 4/1/2008 Qty: 31 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est Rev:D 04-11-17 Reformat JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6063T5A0750W063	Angle6063T5X.75X.75X.063
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Comment: Qty.: 1.0000 f(s)/Unit Total: 30.0000 f(s)
 Material: 6063-T5 (QQ-A-200/9) 0.063" wall
 M6063T5A750W063)
 Identify as D206-547-11
 Batch: M107709 (18x)

08/05/13

M107983 (13x)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut parts to 12.00" length from 0.063" x 0.75" angle

2-Deburr

08/05/13 (31x)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/05/13 (x31)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/05-13

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/14 (31)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:53:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 38170

Part Number: D20654711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 176

overstock

08/05/14 (K3)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.8.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

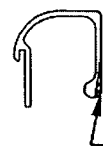
RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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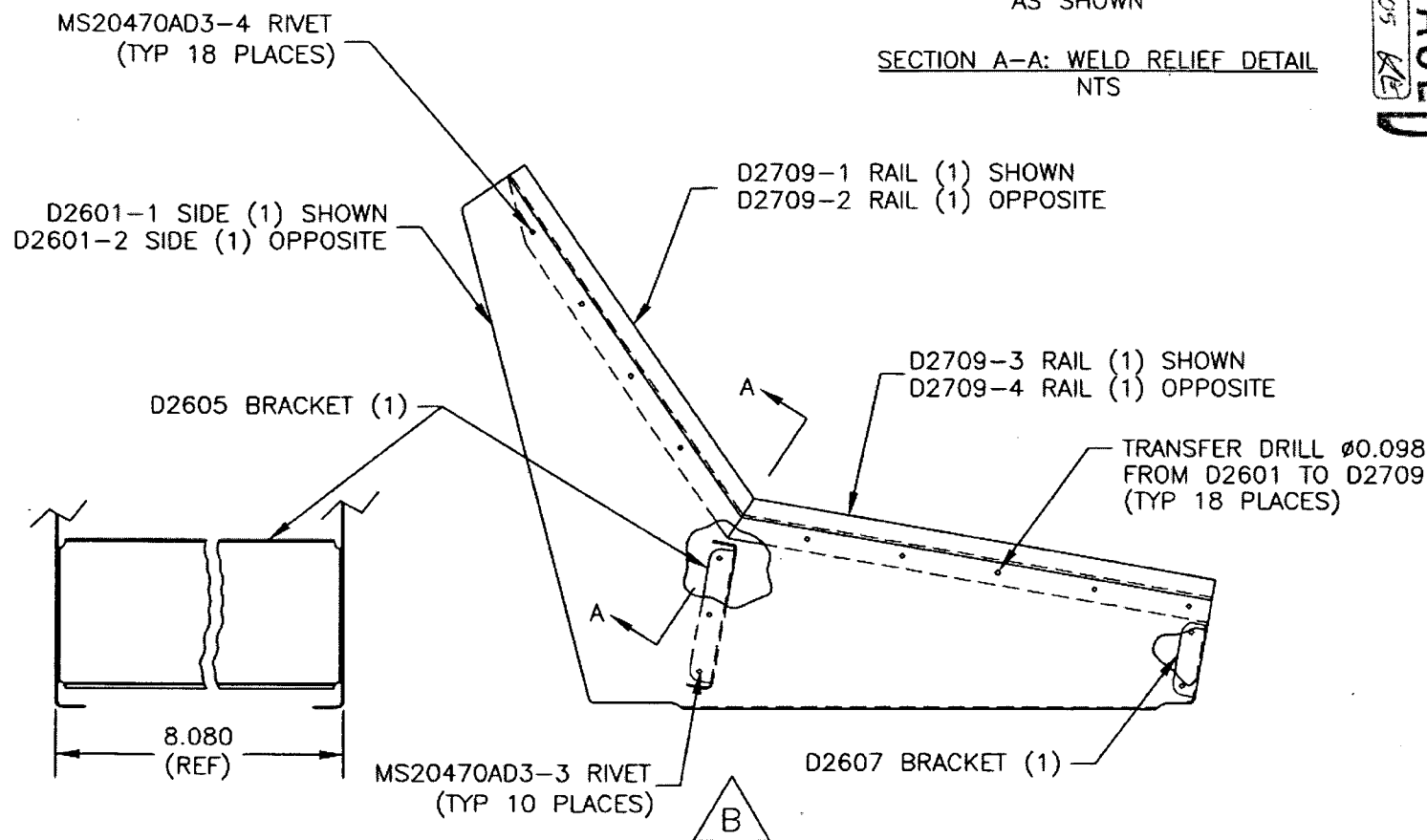
DART

RELEASED
99.03.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

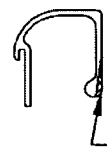
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 2 OF 5
				SCALE 1:4

DART

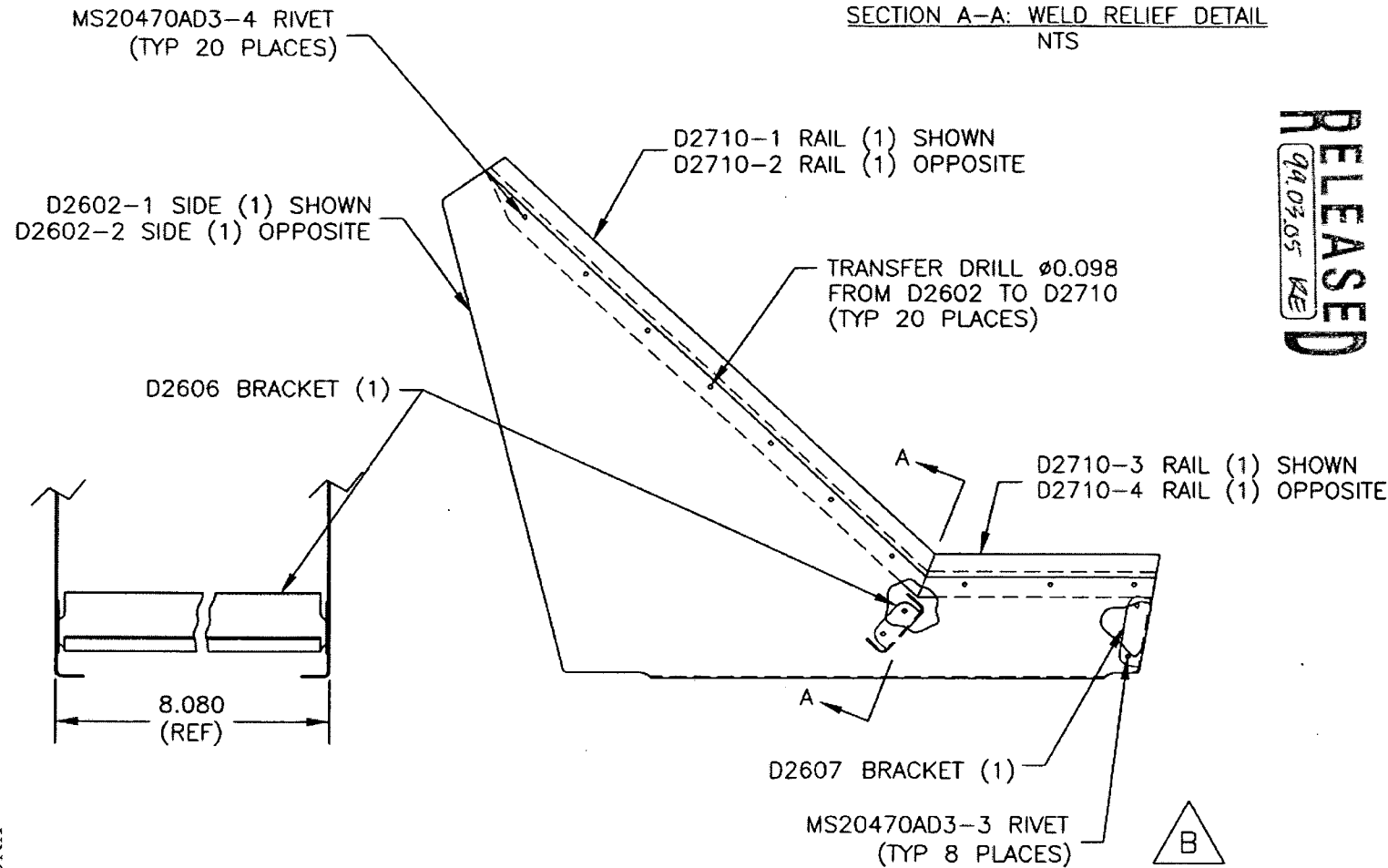
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99.02.05 KE

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DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

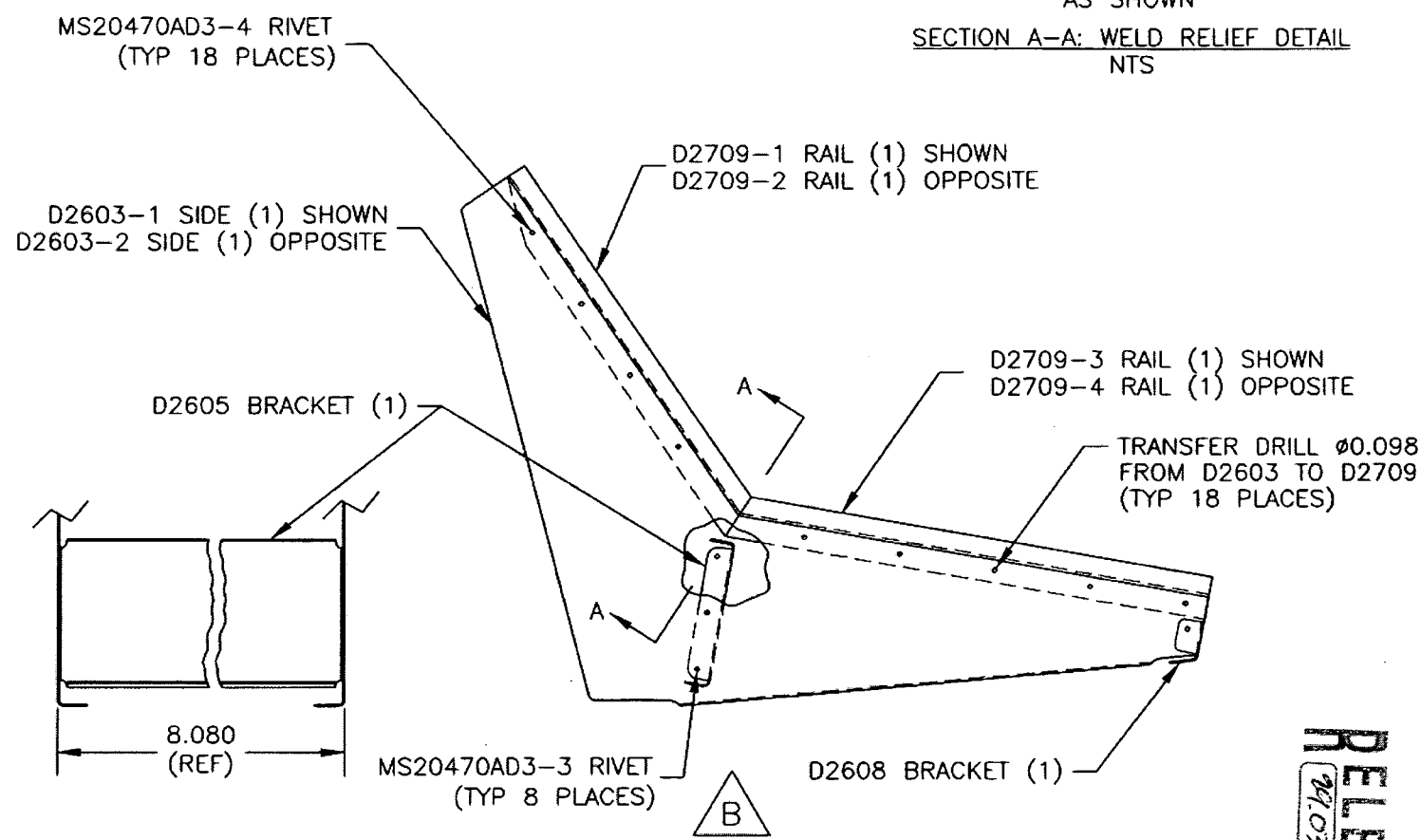
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SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.03.05 AE

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DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

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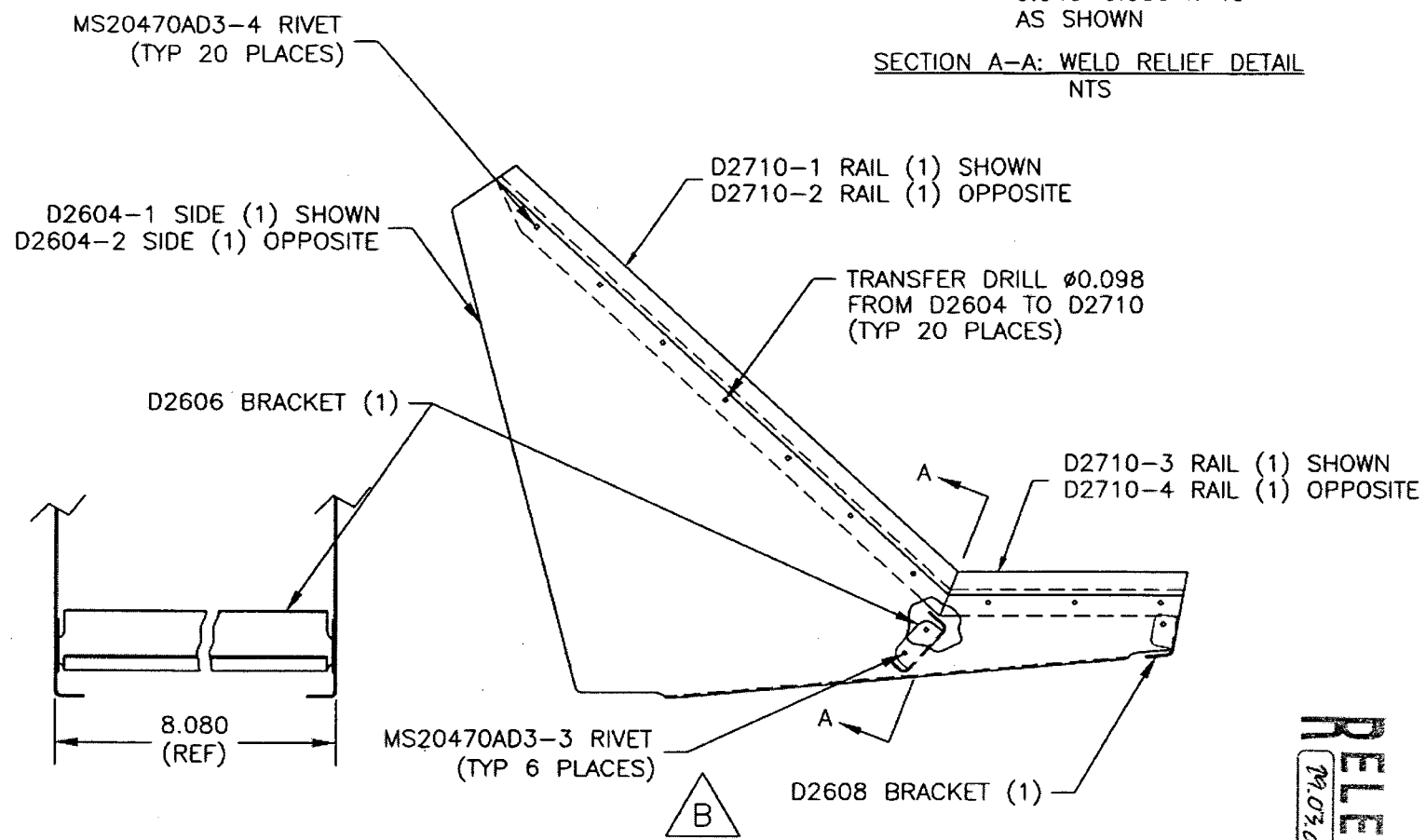
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SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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190305 KE

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		SCALE	1:4	

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